

Ultramid® A 3L HP BK20465

Polyamide 66

BASF Corporation

Product Description

Ultramid A3L HP BK20465 is an unreinforced, impact modified, high flow, nylon 66 for injection molding. This grade has excellent flow and improved ambient and low temperature toughness.

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified • Oil Resistant
Uses	• Fasteners
RoHS Compliance	• RoHS Compliant
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Physical

	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.10	g/cm ³	ASTM D792
--	1100	kg/m ³	ISO 1183 ²

Mechanical

	Nominal Value	Unit	Test Method
Tensile modulus	2440	MPa	ISO 527-2 ²
Tensile Stress (Yield)	63.5	MPa	ISO 527-2 ²
Tensile Strain (Yield)	6.2	%	ISO 527-2 ²
Nominal strain at break	28	%	ISO 527-2 ²
Flexural Modulus (23°C)	2280	MPa	ISO 178

Impact

	Nominal Value	Unit	Test Method
Charpy notched impact strength			ISO 179/1eA ²
-30°C	14.0	kJ/m ²	
23°C	19.0	kJ/m ²	
Notched Izod Impact Strength			ISO 180
-40°C	12.0	kJ/m ²	
23°C	18.0	kJ/m ²	

Thermal

	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa)	70.0	°C	ISO 75-2 ²
Melting Temperature	260	°C	ASTM D3418 ISO 3146

Injection

	Nominal Value	Unit
Drying Temperature	60.0	°C
Drying Time	1.0 to 2.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	288 to 305	°C
Mold Temperature	60.0 to 100	°C
Injection Pressure	3.50 to 12.5	MPa
Injection Rate	Fast	
Back Pressure	0.00 to 0.350	MPa
Screw Speed	40 to 80	rpm
Screw Compression Ratio	3.0:1.0 to 4.0:1.0	

Notes

¹ Typical properties: these are not to be construed as specifications.

² Tested in accordance with ISO 10350. 23°C/50%r.h. unless otherwise noted.

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